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D2885

Job Sheet 207442



34

Part No: D2885

Job Qty: 30 pcs

DAS

Part Name: Saddle Spacer

21

9-00



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/26/20

Job Tracking No:

Due Date: 3/4/20

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP A 99.10.12 New Issue EC IPP Rev:B Now 6060-T6 06-06-23 JLM IPP Rev:C waterjet 06-07-23 ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	30 pcs			0.17	0.45	Waterjet - Flow		TF Feb 26, 2020
110	QC 2	30 pcs			0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		TP Feb 26, 2020
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

120	QC 8	30 pcs	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130	Handfinish - 1-1 Chemical- B4B	30 pcs	0.00 0.18	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140	QC 7	30 pcs	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	

DA
40
8-88

FEB 27 2020

FEB 28 2020

		QC 7 - 17	
		QC 7 - 18	
		QC 7 - 19	
		QC 7 - 2	
		QC 7 - 28	
		QC 7 - 3	
		QC 7 - 30	
		QC 7 - 34	
		QC 7 - 36	
		QC 7 - 37	
		QC 7 - 41	
		QC 7 - 47	
		QC 7 - 48	
		QC 7 - 51	
		QC 7 - 58	
		QC 7 - 59	
		QC 7 - 60	
		QC 7 - 9	
		QC 7 - 68	
		QC 7 - 50	
		QC 7 - 67	
		QC 7 - 40	FEB 28 2020
		QC 7 - 24	DAS 40 9-88
		QC 7 - 43	
		QC 7 - 61	
		QC 7 - 81	
		QC 7 - 76	
		QC 7 - 79	
		QC 7 - 83	
		QC 7 - 82	
150	Packaging 3-1 - Stock - B4B	30 pcs	0.00 0.00
		Packaging 3 - 1 - B4B	
		Packaging 3 - 2 - B4B	
		Packaging 3 - 3 - B4B	
		Packaging 3 - 4 - B4B	
		Packaging 3 - 5 - B4B	
		Packaging 3 - 6 - B4B	
		Packaging 3 - 7 - B4B	
		Packaging 3 - 8 - B4B	
		Packaging 3 - 9 - B4B	
		Packaging 3 - 10 - B4B	
		Packaging 3 - 11 - B4B	
		Packaging 3 - 12 - B4B	
		Packaging 3 - 13 - B4B	
		Packaging 3 - 14 - B4B	
		Packaging 3 - 15 - B4B	
		Packaging 3 - 16 - B4B	
		Packaging 3 - 17 - B4B	
		Packaging 3 - 18 - B4B	
		Packaging 3 - 19 - B4B	
		Packaging 3 - 20 - B4B	
		Packaging 3 - 21 - B4B	DAS
		Packaging 3 - 22 - B4B	84
		Packaging 3 - 23 - B4B	9-89
		Packaging 3 - 24 - B4B	57013
		Packaging 3 - 25 - B4B	
		Packaging 3 - 26 - B4B	
		Packaging 3 - 27 - B4B	
		Packaging 3 - 28 - B4B	
		Packaging 3 - 29 - B4B	

			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
160 QC 21 - SA	30 pcs	0.00 0.00	QC 21 - SA - 21	543
			QC 21 - SA - 70	21
			QC 21 - SA - 53	9-20
			Broussard	

MAR 12 2020

Part Op 100 - 1-Cut as per Dwg D2885 Dwg Rev: B Prog Rev: B 2-Deburr if necessary
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 130 - Chemical Conversion Coat per QSI005 4.1
 140 - QC7-Inspect Chemical Conversion Coat
 150 - Identify as per dwg & Stock Location:
 160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	.7710 sf (.0257 ea)	100-Waterjet - Flow - 1	5232779

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.080	1	387	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle Spacer	0.430Inches ± 0.030	0.460 0.400	0.426	
2	Saddle Spacer	0.443Inches ± 0.010	0.453 0.433	0.447	
3	Saddle Spacer	0.257Inches + 0.006 - 0.001	0.263 0.256	0.257	Diameter
4	Saddle Spacer	0.300Inches ± 0.030	0.330 0.270	0.300	Radius
5	Saddle Spacer	0.679Inches ± 0.010	0.689 0.669	0.679	
6	Saddle Spacer	0.400Inches ± 0.030	0.430 0.370	0.400	Radius
7	Saddle Spacer	0.250Inches + 0.030 - 0.000	0.280 0.250	0.250	
8	Saddle Spacer	0.672Inches ± 0.010	0.682 0.662	0.672	
9	Saddle Spacer	0.521Inches ± 0.010	0.531 0.511	0.521	
10	Saddle Spacer	1.340Inches ± 0.010	1.350 1.330	1.341	
11	Saddle Spacer	2.681Inches ± 0.010	2.691 2.671	2.681	
12	Saddle Spacer	3.710Inches ± 0.030	3.740 3.680	3.700	
13	Saddle Spacer	0.380Inches ± 0.030	0.410 0.350	0.380	Radius
14	Saddle Spacer	0.528Inches ± 0.010	0.538 0.518	0.528	
15	Saddle Spacer	0.080Degrees ± 0.500	0.580 (0.420)	0.079	Angle